

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017957**Date Inspected:** 14-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** N/A**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 006949

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Bike Path. The weld designations reviewed are as follows:

1. BK004A6-006-021, 023, 213, 200, 201, 029, 204
2. BK004A6-006-031, 033, 205, 041, 202, 203, 207, 206, 206, 043
3. BK004A8-006-021, 023, 213, 200, 201, 029, 204
4. BK004A8-006-031, 033, 205, 041, 202, 203, 207, 206, 206, 043

Ultrasonic Testing (UT) – NWIT Document No: 006916

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 12BW. The weld designations reviewed are as follows:

1. CA3009-003, 004

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2. SEG3005A-003, 004
3. SEG3005C- 002, 003, 004, 005, 137
4. SEG3005E-005, 006, 014
5. DP3056-009, 010, 021

Description of Incident: During the Quality Assurance Ultrasonic Testing (UT) review of weld located on OBG Segment 12BW, this Quality Assurance Inspector (QA) discovered one (1) Class “A” indications measuring approximately 20mm in length. The welds are Complete Joint Penetration transition butt joints joining the Corner Detail Section to Floor Beam. The indication details that The Indication rating is +5dB and length approximately 20mm. The Thickness of the plates is 14 and 16mm and depth of the indication approximately 12mm. The indication is located on the weld joint identified as SEG3005E-014. The “Y” location for this indication is approximately 480mm from top edge of the weld. The weld is a Complete Joint Penetration (CJP) transition butt weld joint splice of Corner Detail Section to Floor Beam. This weld joint is designated as non Seismic Performance Critical Member (non SPCM). The OBG segment 12BW is located in the outside of fabrication bay 14. The indications are located within the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC’s QC personnel are required to perform 100% UT inspection of this weld. ZPMC QC is identified as Mr. Wang Wei Ming and he is known about this indication location for future repair with WRR.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
